



May, 24/07/2008 8:20:48 AM  
Annie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT

Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:	Machine Or Operation:	Description :
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20.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S08/08/23 R2

21.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

CART IN/OUT

S08/08/23 R2

22.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



MF 08/10/23



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME:

2:30  
01

OVEN TEMPERATURE:

320°  
01

FINISH TIME:

3:00

(SP)

08/07/31

m-f

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0 PB674300169

90 Degree Cover Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

90 Degree Cover Plate

batch: 40069

FJ 08/07/31 (5)



16.0 PB674300183

PB67-43001-83



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-83

batch: 40096

was done for  
Jones,  
see split  
H 08.08.26



17.0 MS27039110

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Screw

batch: 18836



H 08.08.26

18.0 NAS1149F0316P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

WASHER

batch: 100222 108900



H 08.08.26

19.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



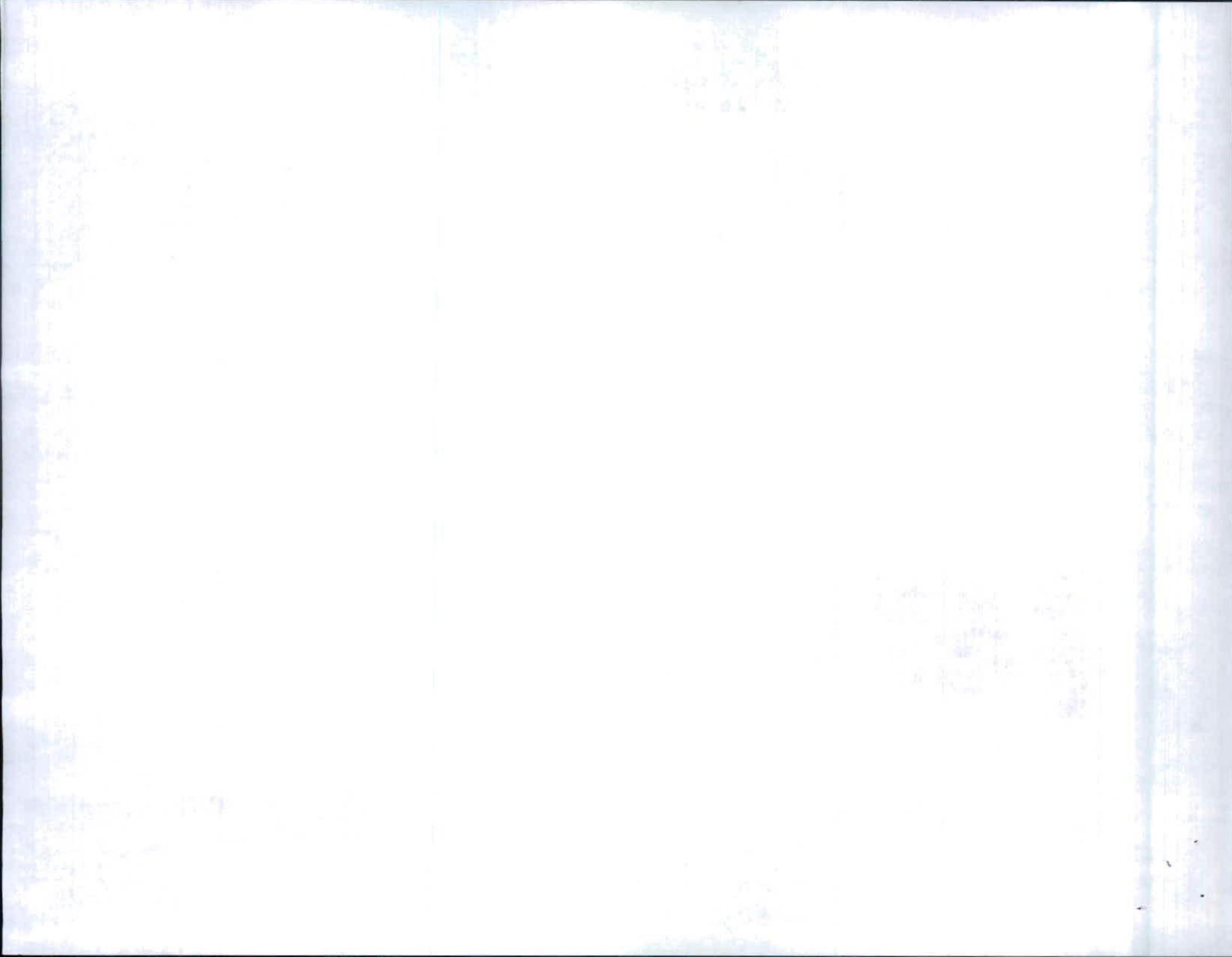
Comment: SMALL & MEDIUM FAB RESOURCE 1

1- match drill cover to existing holes in support

2- assemble as per dwg



H 08.08.26



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 40606

Part Number: PB674300111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- 1- make a 0.090" chamfer in the 1.00" hole before welding
- 2- assemble parts and weld as per dwg

*K* 08-07-22

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*D* 08-07-20(5)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S* 08/08/26 (X) 08-07-29 (

9.0

MS124780

HELICAL INSERT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

HELICAL INSERT

*17935*

*K* 08-01-29

10.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

- 1- grind weld flush in area of PB67-43001-249 only
- 2- tap drill for helical
- 3- install helical insert as per dwg

*K/JBL* 08-07-29 (5)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S* 08/07/29 (5)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*N/A*

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

*(5x)*

1- MASK TUBE FROM BASE TO GUSSET

*> BL 08-07-31*

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

*M/L 08/07/31*



Date: Thursday, 24/07/2008 8:20:48 AM  
User: Melanie Fauteux

## Process Sheet

Customer	: CU-DAR001	Dart Helicopters Services	Drawing Name	: FWD ADJUSTABLE BLADE SUPPORT ASSY
Job Number	: 40606		Part Number	: PB674300111
Estimate Number	: 13435		Drawing Number	: B6743001 P.8
P.O. Number	:		Project Number	: N/A
This Issue	: 24/07/2008	S.O. No. :	Drawing Revision	: B1
Prsht Rev.	: NC		Material	:
First Issue	: 17/07/2008	Type : LARGE FAB ASSY	Due Date	: 24/07/2008
Previous Run	:		Qty:	5
Written By	:		Um:	Each
Checked & Approved By	<i>MF 08-07-24</i>			
Comment	Est Rev:A 08-06-26 new issue DD verified by:ec			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PB6743001247	Inner Tube	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube batch: <i>340689</i>	<i>M 08-07-2</i>
2.0	PB6743001249	Inner Tube Bushing	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Inner Tube Bushing batch: <i>10537</i>	<i>M 08-07-2</i>
3.0	PB6743001253	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: <i>340045</i>	<i>M 08-07-2</i>
4.0	PB6743001254	Gusset	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Gusset batch: <i>B40053</i>	<i>M 08-07-2</i>
5.0	PB674300167	PB6743001-67	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) PB6743001-67 batch: <i>340243</i>	<i>M 08-07-2</i>